

Date: Thursday, 26/06/2008 9:57:29 AM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	CHAFING SHIELD
<b>Job Number</b> :	40109		
<b>Estimate Number</b> :	11138		
<b>P.O. Number</b> :		<b>Part Number</b> :	D31901
<b>This Issue</b> :	26/06/2008	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D3190 REV A
<b>First Issue</b> :	1/1	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	37969	<b>Drawing Revision</b> :	A
		<b>Material</b> :	
<b>Written By</b> :		<b>Due Date</b> :	11/07/2008
<b>Checked &amp; Approved By</b> :	JUL 08.06.26	<b>Qty:</b>	20 Um: Each
<b>Comment</b> :	Est. A 03.05.26 New issue KJ/RF		

## Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

M304S25GA

304/316 .020" Sheet



**Comment:** Qty.: 0.2261 sf(s)/Unit Total : 4.5213 sf(s)

304/316 SS .020" Sheet

Material: AISI 304/316 SS 0.020" thick sheet

(M304S25GA)

Batch: M10 7436

2.0

SHEAR

SHEAR



**Comment:** SHEAR

Cut blank: 9.25" x 3.13"

Grind corner as per Dwg D3190

Deburr

Roll as per Dwg D3190

EB 08/07/02 (20)

EB 08/07/02 (20)

3.0

QC5

INSPECT WORK TO CURRENT STEP



**Comment:** INSPECT WORK TO CURRENT STEP

S 08/07/02 (20)

counted

4.0

PACKAGING 1

PACKAGING RESOURCE #1



**Comment:** PACKAGING RESOURCE #1

Identify and Stock

Location: LG

ml 08 07 03 (20)

5.0

QC21

FINAL INSPECTION/W/O RELEASE



**Comment:** FINAL INSPECTION/W/O RELEASE

08/07/03

Job Completion



mf 08-07-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

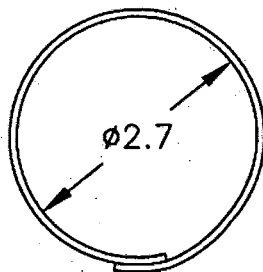
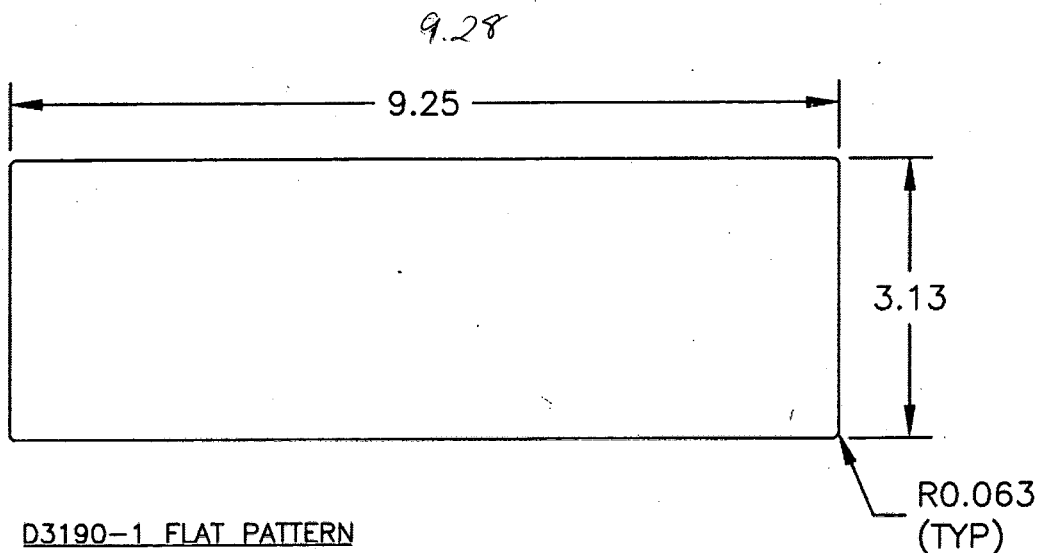
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN #	DRAWN BY UP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3190	REV. A SHEET 1 OF 1
DATE 03.05.16		TITLE CHAFING SHIELD	SCALE 1:2
A	03.05.16	NEW ISSUE	

RELEASED  
03.05.22 #



D3190-1 ROLLING DETAIL  
NOT TO SCALE

D3190-1 CHAFING SHIELD

- 1) MATERIAL: AISI 304/316 SS 0.020" THICK (REF. DART SPEC M304S25GA)
- 2) FINISH: NONE
- 3) DEBURR/BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 40109

Copyright © 2003 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.